

GREEN

Dart Aerospace Ltd.

Date: Thursday, 4/26/2007 3:33:56 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 32077		
Estimate Number	: 10531		
P.O. Number	: N/A	Part Number	: D2572
This Issue	: 4/26/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2572 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31720	Drawing Revision	: E
		Material	: N/A
		Due Date	: 5/30/2007
Written By	: <u>JA 07.04.26</u>	Qty:	10 Um: Each
Checked & Approved By	: <u>JA 07.04.26</u>		
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: B25350

mll

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 32076 Double check by: JL

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

mll/cn 07/05/30 (x10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

mll/cn 07/05/30 (x10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mll/cn 07/05/30 (x10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/26/2007 3:33:56 PM
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Customer: CU-DAR001 Dart Helicopters Services

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Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.05.30

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-05-30

(10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat - OLIVE DRAB GREEN

(Ref: 4.3.5.1) as per QSI 005 4.3

FD

07/06/05

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/06/05 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/05 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/05

(10)

Job Completion



07.06.05

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32077
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.499	3.499	3.499		
D	1.745	1.755		1.749	1.749	1.749	1.749		
E	7.990	8.010		8.001	8.000	8.002	8.002		
F	0.490	0.510		0.502	0.503	0.502	0.502		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.503	0.501	0.502	0.502		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.573	0.570	0.570	0.570		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.493	1.493	1.493	1.494		
N	2.495	2.505		2.499	2.499	2.499	2.500		
O	3.869	3.879		3.871	3.871	3.871	3.871		
P	0.115	0.135		0.126	0.126	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.252	0.252		
S	0.115	0.135		0.127	0.126	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.239	0.241		
W	0.115	0.135		0.126	0.128	0.130	0.129		
X	0.307	0.312		0.311	0.309	0.311	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.356	0.359	0.359	0.359		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.631	0.631	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.249	0.248	0.247		
AE	1.375	1.395		1.386	1.387	1.388	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.240	0.240	0.245	0.245		
AH	0.240	0.260		0.249	0.248	0.248	0.250		
AI	2.000	2.020		2.000	2.000	2.003	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>gnd</i>
Date:	07/05/28

Audited by:	<i>SA</i>
Date:	07.05.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>gnd</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32077
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

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Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.747	1.747	1.746		
C	3.495	3.505		3.499	3.497	3.499	3.498		
D	1.745	1.755		1.749	1.747	1.747	1.746		
E	7.990	8.010		8.002	8.004	8.002	8.000		
F	0.490	0.510		0.502	0.499	0.498	0.496		
G	0.257	0.262	DT8683	0.258	0.258	0.260	0.260		
H	0.375	0.380	DT8684	0.376	0.376	0.377	0.377		
I	0.490	0.510		0.502	0.502	0.498	0.498		
J	1.174	1.184		1.177	1.177	1.178	1.177		
K	0.558	0.578		0.570	0.570	0.565	0.567		
L	1.174	1.184		1.177	1.177	1.178	1.177		
M	1.490	1.500		1.493	1.493	1.493	1.494		
N	2.495	2.505		2.506	2.499	2.498	2.496		
O	3.869	3.879		3.871	3.871	3.872	3.873		
P	0.115	0.135		0.126	0.126	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.252	0.252		
S	0.115	0.135		0.124	0.124	0.127	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.237	0.237		
W	0.115	0.135		0.130	0.122	0.124	0.126		
X	0.307	0.312		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.765	0.765	0.765		
Z	0.352	0.372		0.358	0.360	0.360	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.626	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	0.246	0.247		
AE	1.375	1.395		1.388	1.389	1.387	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.240	0.246	0.260	0.260		
AH	0.240	0.260		0.249	0.249	0.248	0.246		
AI	2.000	2.020		2.001	2.002	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>Amr 1/Ep</i>
Date:	07/05/25

Audited by:	07.05.30
Date:	SA

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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E	7.990	8.010		8.003	8.001				
F	0.490	0.510		0.496	0.494				
G	0.257	0.262	DT8683	0.260	0.260				
H	0.375	0.380	DT8684	0.377	0.377				
I	0.490	0.510		0.499	0.498				
J	1.174	1.184		1.175	1.175				
K	0.558	0.578		0.564	0.567				
L	1.174	1.184		1.175	1.175				
M	1.490	1.500		1.491	1.492				
N	2.495	2.505		2.497	2.497				
O	3.869	3.879		3.872	3.872				
P	0.115	0.135		0.126	0.126				
Q	0.115	0.135		0.135	0.135				
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S	0.115	0.135		0.127	0.120				
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U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.241	0.241				
W	0.115	0.135		0.128	0.124				
X	0.307	0.312		0.311	0.311				
Y	0.760	0.765		0.765	0.765				
Z	0.352	0.372		0.360	0.362				
AA	0.470	0.530		0.500	0.500				
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AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by: En
Date: 07/05/30

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Date: 07.05.30

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Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED

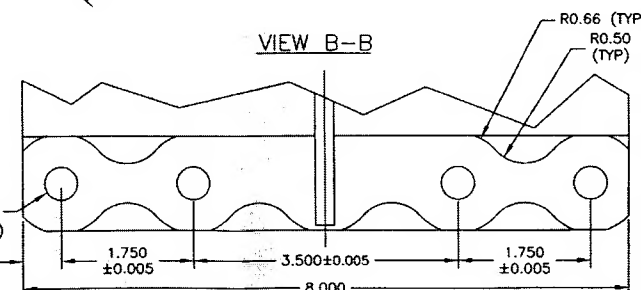
05.12.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
 (REF DART SPEC. D6102-003)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
 3 CHAMFER 0.063 x 45° ALL AROUND
 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

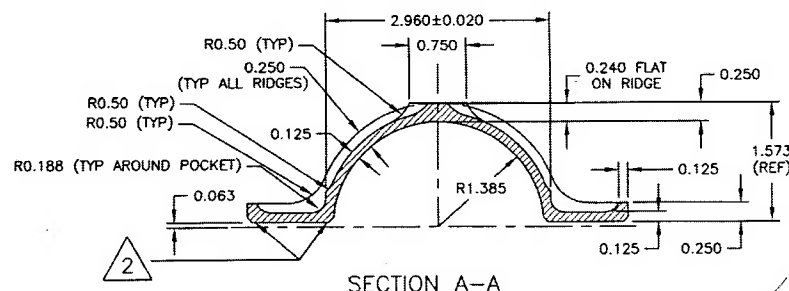
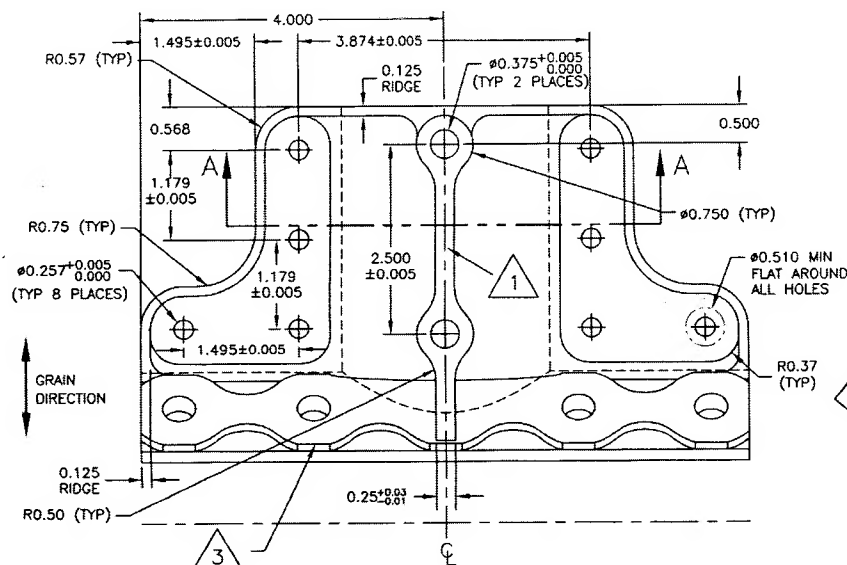
VIEW B-B



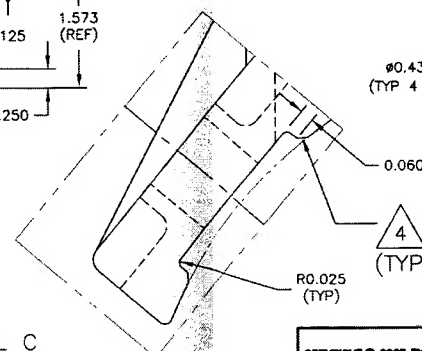
E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE
		INNER FWD SADDLE
		SCALE 2:3

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 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE LTD.



SECTION A-A

DETAIL C
SCALE 2:1

NO. 33077
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 ENGINEERING
 RETURN TO
 SHOP COPY

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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